<u> </u>												
<b>Work Order</b> Wednesday, Octob	r <b>ID 62692</b> ber 06, 2010 11:13:47 A	M										Page 1
Item ID: D Revision ID:	03574-5			Accept					Setup			
Item Name: C	Cabin Floor Protector									Stop		
Required Date: 1	0/6/2010 Start Qty: 0/15/2010 Req'd Qty				Cust Item I Customer:	ID:						
Reference:												
Approvals:	Process Plan:	/ Da	te:/0-00-0C	Tooling:	D	ate:			Run	Start Stop		
•	QC:	Da	te:	_ SPC (Y/N):	D	ate:	<del></del>			жор		
Sequence ID/ Work Center ID	Operation Description	1		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr											
D3574	Rev B											
100	FLOW WATE	ER JET		0.00				Ru	<i>ان</i> .	6		
Waterjet	M	1emo		0.00				(.).c(.)	<u> </u>			
FLOW CNC Waterjet		-Cut as per Dwg I beburr if necessary		v: <b>g</b> □Prog Rev:_							3	
	QC2- Inspect	parts off machine	FAI/FAIB	0.00				1B 10	\~ (()	\-fa		
QC Quality Control	N	1emo		0.00			•	125 10	<u>ي ر</u>	<u> </u>	•	

120

QC Memo Quality Control

QC8- Inspect parts - second check

2000

<u>~3</u> \_\_\_

-5

W/O:			WO	RK ORDER CHAN	GES					<del>-</del>
DATE	STEP	PR	OCEDURE CHAN	IGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR:	Yes N	10 <b>DQ</b>	A:	_ Date: _	
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NCR:			WORK ORDE	R NON-CONFORM	ANCE (	NCR)	•		_	
DATE	0750	Description of NC			ection B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1 5	Sign & Date	Secti		Chief Eng	QC Inspector
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#### Work Order ID 62692

Wednesday, October 06, 2010 11:13:47 AM



Page 2

Item ID:

D3574-5

Accept

Setup Start



**Revision ID:** 

Item Name:

Cabin Floor Protector

**Start Date:** 

10/6/2010

Start Qty: 3.00

Req'd Qty: 3.00 **Required Date:** 10/15/2010



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Tooling: Date:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Work Center ID

QC:

Operation

Description

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

130

Sequence ID/

Small Fab Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

Memo

0.00

Packaging

		<del></del>							
W/O:			WO	RK ORDER CHANG	ES				-
DATE	STEP	PR	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	Jory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Res	olution:	Disposition	):	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	0750	Description of NC		Corrective Action Sect	ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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#### Work Order ID 62692

Wednesday, October 06, 2010 11:13:47 AM



Page 3

Item ID:

D3574-5

Accept



Setup Start

**Revision ID:** 

Item Name: Cabin Floor Protector

**Required Date:** 10/15/2010

Stop

**Start Date:** 

10/6/2010

Start Qty: 3.00 **Req'd Qty:** 3.00

**Cust Item ID: Customer:** 

Reference:

A	nn	rov	/a	s:

Process Plan:

Date:

**Tooling:** 

Date: \_\_\_\_\_

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

**Work Center ID** 

Operation Description

Set Up/ **Run Hours**  **Tool ID** 

Tool # Plan Code

Accept Qty

Run

Reject

Insp. Number Stamp

160

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Reject

Qty

Quality Control

10/07 95 MF 10-10-07

W/O:			W	ORK ORDER CHANG	ES				-
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C (	Closed:		Date: _	
NCR:		V	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	ication	Approval	Approvai
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector
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				- Control of the cont					

## **Picklist Print**

Wednesday, October 06, 2010 11:13:52 AM

Work Order ID: 62692

D3574-5 Parent Item:

Parent Item Name: Cabin Floor Protector

**Start Date:** 10/6/2010

**Required Date:** 10/15/2010

Page 1

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev : A New Issue 07.07.23 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,185.803		100.8504	120	•	
										Ø	Z1~10.	- 6	

GE PLASTICS LEXAN SHEET

**Location** Loc Qty Loc Code MAT 2185.8038 184.9238 114032 2000.88 115261

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	0.750	Description of NC			ion B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Sect	ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	62692
Description: Cabin Floor Protector	Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	loierance	Dimension	Accept	, reject	Inspection	
Ø3.00	+0.006/-0.001	3,003	ף		V BOD	
7.37	+/-0.030	7.37	×		T BOI	
11.00	+/-0.030	11.06	<b>*</b>		T	
15.25	+/-0.030	15,25	177		7	
25.87	+/-0.030	78.76	Þ		7	
39.75	+/-0.030	3975	TP.		+	
44.75	+/-0.030	44.75	d		7	· · · · · · · · · · · · · · · · · · ·
49.11	+/-0.030	49.11	A		17	
51.11	+/-0.030	SILL	*		7	
1.75	+/-0.030	125	₽		7	
58.38	+/-0.030	5.8.39	*		~	
63.50	+/-0.030	(3,50	x		T	
65.25	+/-0.030	64.25	R.		7	
44.07	. ( 0.000	0-1	1			
11.87	+/-0.030	(1.87	18		7	
14.75	+/-0.030	14.75	, o		Τ	
26.00	+/-0.030	26.06	<b>⅓</b>		ΙΤ	
40.87	+/-0.030	4087	<del> </del>		7	
45.00	+/-0.030	45.00	<u>8</u>		T	+4
48.00	+/-0.030	48.00	\ <del>X</del>		T	. ~
55.13	+/-0.030	55.13	<b>A</b>		7	
58.38	+/-0.030	58.38	7		7	
61.25	+/-0.030	61.05	8		T	
61.88	+/-0.030	61.88	7		7	
64.63	+/-0.030	64.63	চ		7	<u>.                                    </u>
			,			<del></del>
7.63	+/-0.030	7.63	de		7	
11.00	+/-0.030	11-00	>>		7	
22.50	+/-0.030	23.50	760		7	
35.13	+/-0.030	35.13	74.		7	
36.50	+/-0.030	36.50				<del></del>
40.00	+/-0.030	40.00	ठ		1	·
41.88	+/-0.030	41.88	<b>%</b> -	-	7	
43.63	+/-0.030	43.63	Υ		T	·
6.75	W 0 020	1 7	0		7	<del></del>
6.75	+/-0.030	6.75	0			

W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	R	esolution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:		V	ORK ORD	R NON-CONFORMA	NCE (NCF	R)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	12692
Description: Cabin Floor Protector	Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 2 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

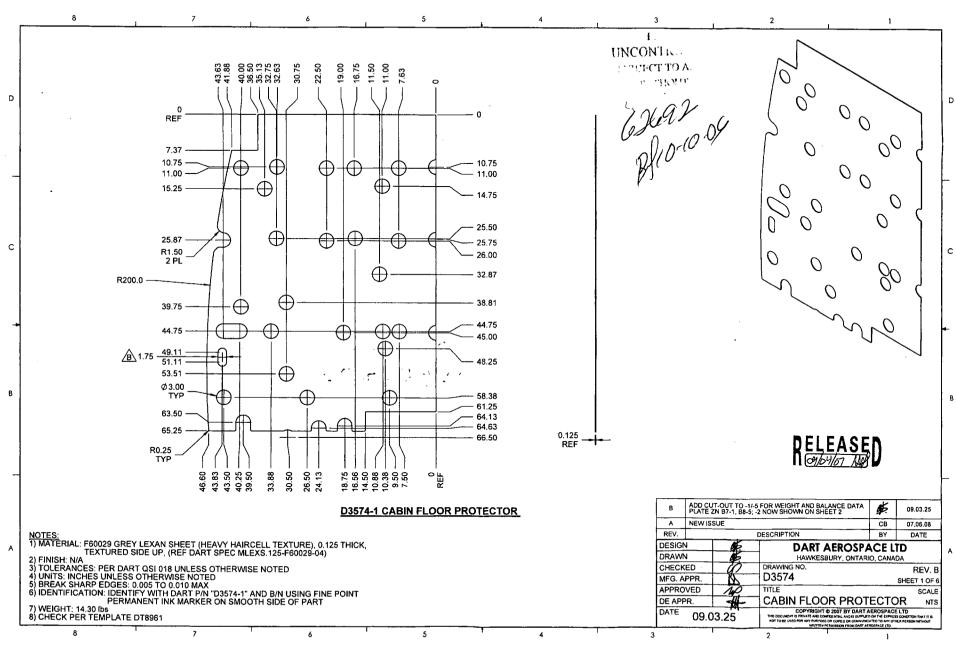
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9,50	×		T 1301	
10.38	+/-0.030	10.38	7		7	
14.50	+/-0.030	1450	*		7	
16.75	+/-0.030	16.75	×		7	
19.00	+/-0.030	19.00	8		T	
24.13	+/-0.030	24.13	مز		4	<u> </u>
33.88	+/-0.030	33.88	<b>×</b>		+	
39.50	+/-0.030	39:50	4		T	
40.25	+/-0.030	40.05	R		7	•
43.50	+/-0.030	43,50	汝		7	
43.83	+/-0.030	43.83	R		7	
46.60	+/-0.030	46.60	8		7	
0.125	+/-0.010	198	4		V 1302	
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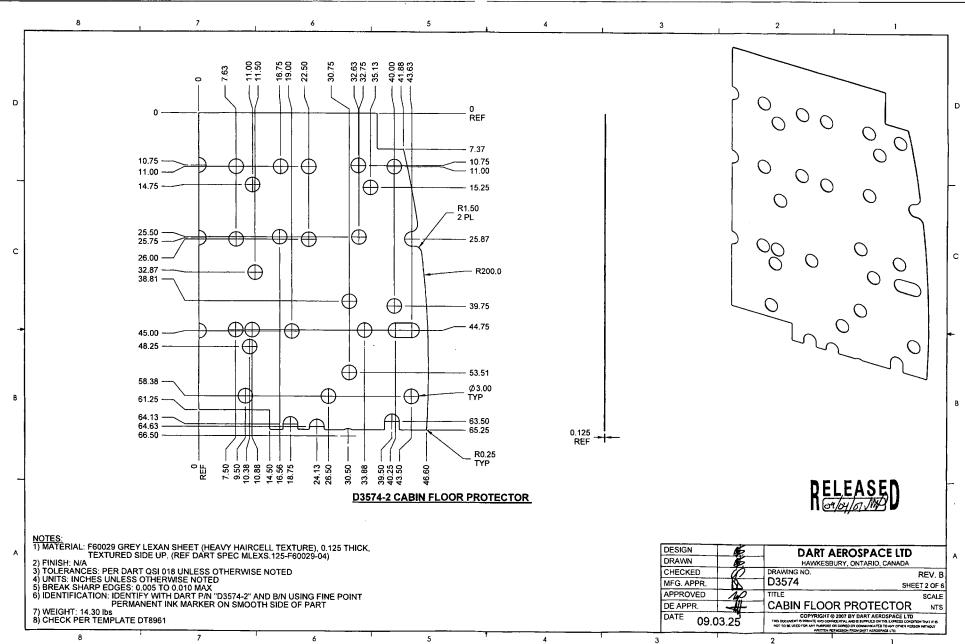
Measured by:	(B)	Audited by:		Prototype Approval:	N/A	
Date:	10-10-6	Date: (O	10/06	Date:	N/A	

Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ//DD	
В	08.07.31	1.13 dimension removed	KJ/DD	L
С	09.05.15	Dimensions updated per Dwg Rev B	KJ 🐪	

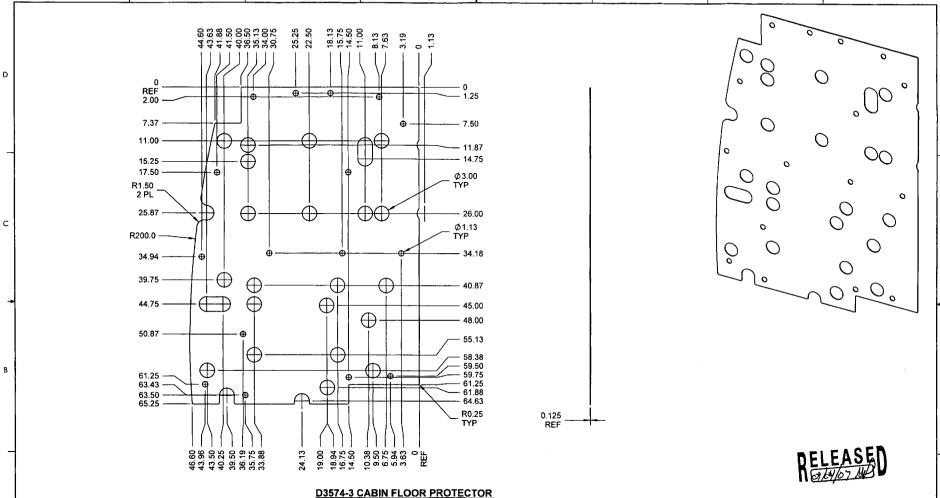
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W/O:			WO	RK ORDER CHANGI	ES	***************************************			
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
Resolution:		esolution:	Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	3)			
DATE		Description of NC			on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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W/O:			WC	ORK ORDER CHANG	GES					
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		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:					
Resolution:			Dispositio	n:	QA: N/0	C Clos	sed:		Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC	Corrective Action Section B				Verific	cation	Approval	Approvai
	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section		on C	Chief Eng	QC Inspector
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W/O:			WO	RK ORDER CHANG	ES				
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Part No	:	PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Resolution:								
NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NCR	1)			
DATE	OTED	Description of NC	Corrective Action		on B	Verification		Approval	Approval
DATE	STEP	Section A	A Initial Action Description Chief Eng Chief Erg		Sign & Date	Section C		Chief Eng	QC Inspector
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NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

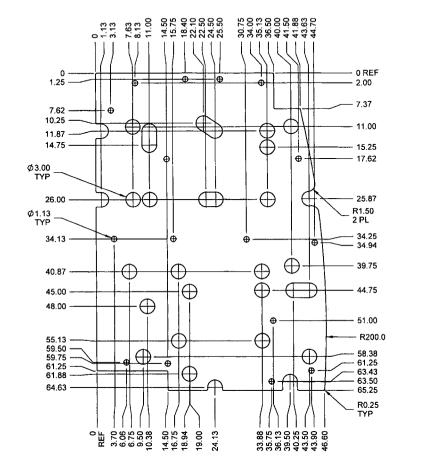
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

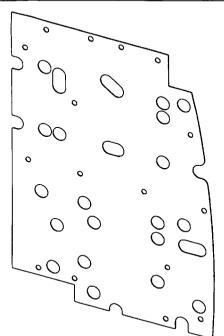
7) WEIGHT: 14.33 lbs 8) CHECK PER TEMPLATE DT8962

DESIGN	45	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	00	DRAWING NO.	REV. B
MFG. APPR.	N.	D3574 <sub>SHE</sub>	ET 3 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	-#	CABIN FLOOR PROTECTOR	NTS

09.03.25

W/O:			WO	RK ORDER CHANGI	ES				·· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Resolution:		Disposition	n:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A		Corrective Action Section		Verific	cation	Approval Chief Eng	Approval
DATE			Initial Chief Eng	Action Description  Chief Eng	Sign & Date	& Secti			QC Inspector
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#### **D3574-4 CABIN FLOOR PROTECTOR**

NOTES.

1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

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2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

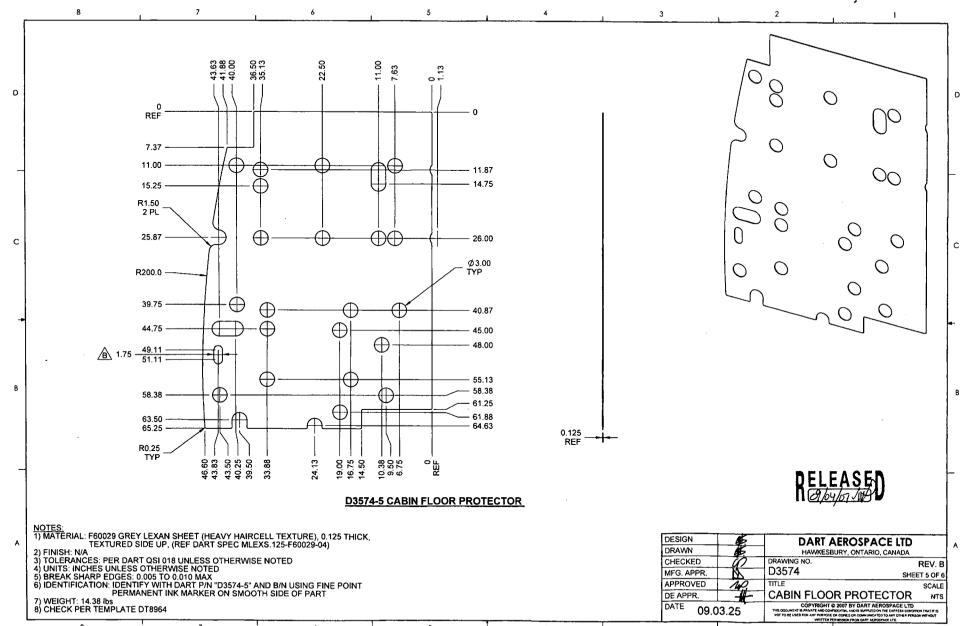
7) WEIGHT: 14.18 lbs 8) CHECK PER TEMPLATE DT8963

DESIGN	1	DART AEROSPACE LTD					
DRAWN	165	HAWKESBURY, ONTARIO, CANADA					
CHECKED	00		V. B				
MFG. APPR.	100	D3574 SHEET 4	OF 6				
APPROVED	10	TITLE SO	ALE				
DE APPR.		CABIN FLOOR PROTECTOR	NTS				
DATE 09.0	03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COMMENT HAT IT IS NOT TO BE USED FOR ANY PARPOSE OR COMPED OR COMMENCENTED TO ANY OTHER PRESCRIPTION.					

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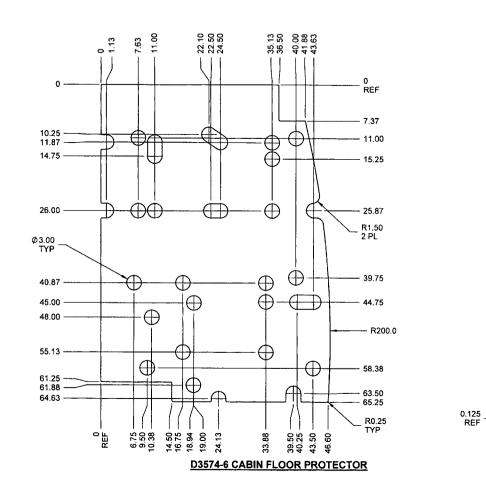
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	<b>A</b> :	Date: _	
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	Re	solution:	Dispositio	າ:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
		Description of NC	Corrective Action		Section B		cation	Approval	Approval
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		10 July 18 May 19 July							
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NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

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2) FINISH: N/A

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965

DESIGN	16	DART AEROSPACE LTD				
DRAWN	45	HAWKESBURY, ONTARIO, CANADA				
CHECKED	00	DRAWING NO.	REV. B			
MFG. APPR.	10/	D3574 <sub>SHEI</sub>	T 6 OF 6			
APPROVED	160	TITLE	SCALE			
DE APPR.	4	CABIN FLOOR PROTECTOR	NTS			
DATE 09 (	3 25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONSTIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS				

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W/O:			WO	RK ORDER CHANGI	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date:	
Resolution:		Disposition	Disposition:		QA: N/C Closed:			_ Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC	Corrective Action Section			Verification		Approvai	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
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